SOLO®
XL Combo
Automatic Wrapper/Labeler
User's Guide

83166400A
(8/00).00

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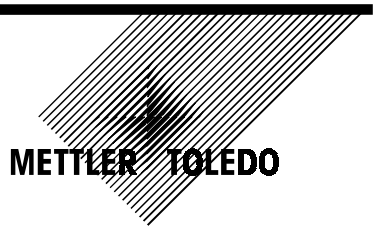

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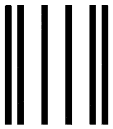

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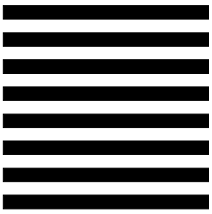

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This device complies with Part 15 of the FCC Rules and the Radio Interference Requirements of the Canadian Department of Communications. Operation is subject to the following conditions: (1) this device may not cause harmful interference, and (2) this device must accept any interference received, including interference that may cause undesired operation.

This equipment has been tested and found to comply with the limits for a Class A digital device, pursuant to Part 15 of FCC Rules. These limits are designed to provide reasonable protection against harmful interference when the equipment is operated in a commercial environment. This equipment generates, uses, and can radiate radio frequency energy and, if not installed and used in accordance with the instruction manual, may cause harmful interference to radio communications. Operation of this equipment in a residential area is likely to cause harmful interference in which case the user will be required to correct the interference at his own expense.

PRECAUTIONS

READ this manual BEFORE operating or servicing this equipment.

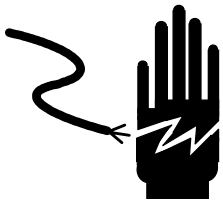
FOLLOW these instructions carefully.

SAVE this manual for future reference.

DO NOT allow untrained personnel to operate, clean, inspect, maintain, service, or tamper with this equipment.

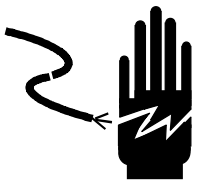
ALWAYS DISCONNECT this equipment from the power source before cleaning or performing maintenance.

CALL METTLER TOLEDO for parts, information, and service.



WARNING

ONLY PERMIT QUALIFIED PERSONNEL TO SERVICE THIS EQUIPMENT. EXERCISE CARE WHEN MAKING CHECKS, TESTS AND ADJUSTMENTS THAT MUST BE MADE WITH POWER ON. FAILING TO OBSERVE THESE PRECAUTIONS CAN RESULT IN BODILY HARM AND/OR PROPERTY DAMAGE.



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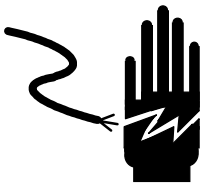

WARNING

DISCONNECT ALL POWER TO THIS UNIT BEFORE REMOVING THE FUSE OR SERVICING.

CAUTION

BEFORE CONNECTING OR DISCONNECTING ANY INTERNAL ELECTRONIC COMPONENTS OR INTERCONNECTING WIRING BETWEEN ELECTRONIC EQUIPMENT, ALWAYS REMOVE POWER AND WAIT AT LEAST THIRTY (30) SECONDS BEFORE ANY CONNECTIONS OR DISCONNECTIONS ARE MADE. FAILURE TO OBSERVE THESE PRECAUTIONS COULD RESULT IN DAMAGE TO, OR DESTRUCTION OF THE EQUIPMENT OR BODILY HARM.

CAUTION

OBSERVE PRECAUTIONS FOR HANDLING ELECTROSTATIC SENSITIVE DEVICES.

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METTLER TOLEDO® reserves the right to make refinements or changes without notice.

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1 General Description

The METTLER TOLEDO Model SOLO® XL Combo is an Automatic Wrapper designed to wrap, weigh, and label tray-contained products with stretch films. The wrapper is not designed to wrap loose and/or liquid products.

The SOLO® XL Combo is designed for easy operation and reduced film and labor costs. The SOLO® XL Combo is meant for use in prepackaging backroom environments. This unit is not intended for washdown or hazardous area operation, or for operation in environments of extreme dust, heat, cold, or humidity.

ISO9001
This product was developed, produced and tested in a METTLER TOLEDO facility that has been audited and registered according to international (ISO 9001) quality standards.

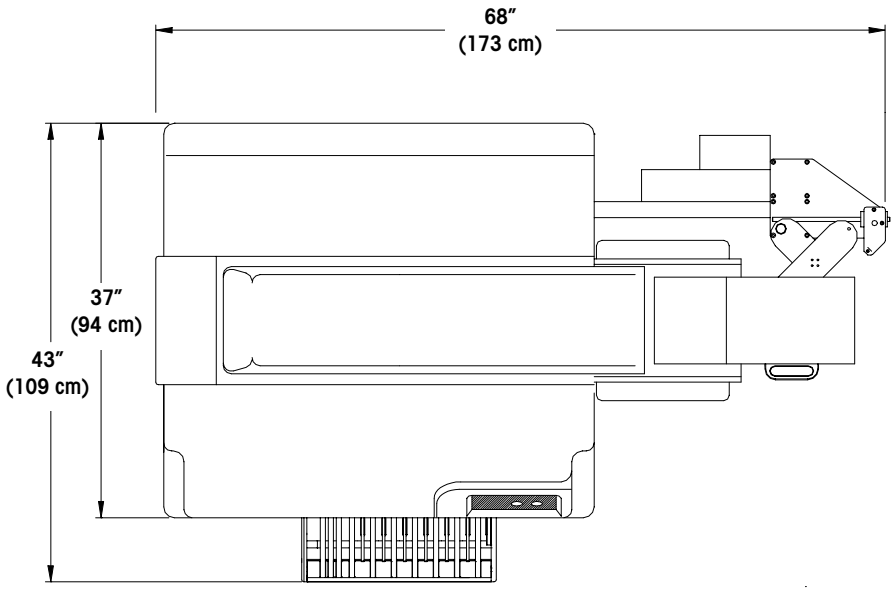
SOLO® XL Combo

Specifications

Agency Approvals	ETL Approved Conforms to UL 763 and CSA C22.2
Noise Level Specifications	Equivalent continuous weighted sound pressure level at the workstation is 74.4 dB. Tests performed in conformance with ISO 3746 Standard (UNI 7712-AFNOR S31-069)
Footprint	20.6 sq. ft.
Film size	13 inch
Packages Per Minute	20 maximum
Min. tray size: length	7.08 in. (180 mm)
Min. tray size: width	5.11 in. (130 mm)
Min. tray size: height	0.78 in. (20 mm)
Max. tray size: length*	15.75 in. (400 mm)
Max. tray size: width*	11.40 in. (290 mm)
Max. tray size: height*	5.00 in. (127 mm)
Voltage Requirements (Combo Components)	115 VAC/50-60 Hz, 15A Supply (Includes Combo Control Box, Printer, Scale, and Scale Lifter.)
Voltage Requirements (XL Wrapper Only)	115 VAC/50-60 Hz, 30A Supply 208 VAC/50-60 Hz, 20A Supply 230 VAC/50-60 Hz, 20A Supply
Internal Operating Voltage	48 VAC
Shipping Weight	825 lb
Recommended Operating Temperature Range	40°F to 95°F (5°C to 35°C)
Humidity	5% to 95% Non-condensing

* Tray can only be at the maximum limit in one dimension.

Dimensions



XL Combo Dimensions

2 Safety Instructions

WARNING

Failure to comply with the following instructions could result in personal injury or damage to the equipment.

Precautions

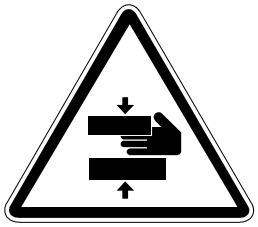
The SOLO® XL Combo should be operated only by trained personnel. Do not wear loose or torn clothes, a hanging tie, or jewelry when operating the machine. Keep long hair away from any moving parts. Follow the directions contained in this guide.

Be careful when working near the sealing belt, even when the machine is turned off.

WARNING

The SOLO® XL Combo has an electrically heated sealing belt. Do not touch this belt.

When a package is placed on the infeed conveyor, the machine will automatically start and will stop when the wrapped package is ejected on the sealing belt.



WARNING

Do not put your hands beyond the Infeed Door or beyond the Sealing Belt exit opening while the machine is operating or powering up. On power up, the SOLO® XL Combo will run a self-test. During the self-test, Infeed Belts are in motion and other motors are running. Do not place materials on the belts during this test.

Do not remove any safety covers or disable any safety devices.

Do not use the machine if it is damaged or malfunctioning.

Only wrap the indicated tray sizes.

When the machine will not be used for extended periods of time, rotate the Power Switch to **O** to shut down.

Cleaning and Maintenance

CAUTION!

Always turn the Power Switch to OFF whenever the machine is left idle or during maintenance, cleaning, or before changing film.

Allow the Sealing Belt to cool before cleaning.

Do not attempt to make repairs to the machine. Service repairs must be performed by trained personnel only.

Do not direct water spray or steam at the inside or outside of the machine.

Safety Devices

The SOLO® XL Combo incorporates several safety interlock devices to keep the operator safe and to avoid damage to the machine or service interruptions due to incorrect operation. All covers must be in place for the machine to operate.

The machine is supplied with a transformer mounted underneath the machine and is protected by a circuit breaker located underneath the front cover near the main power switch.

Where there is access to moving parts, suitable warning labels are posted to identify potential hazards.

3 Operating Instructions

Component Locator

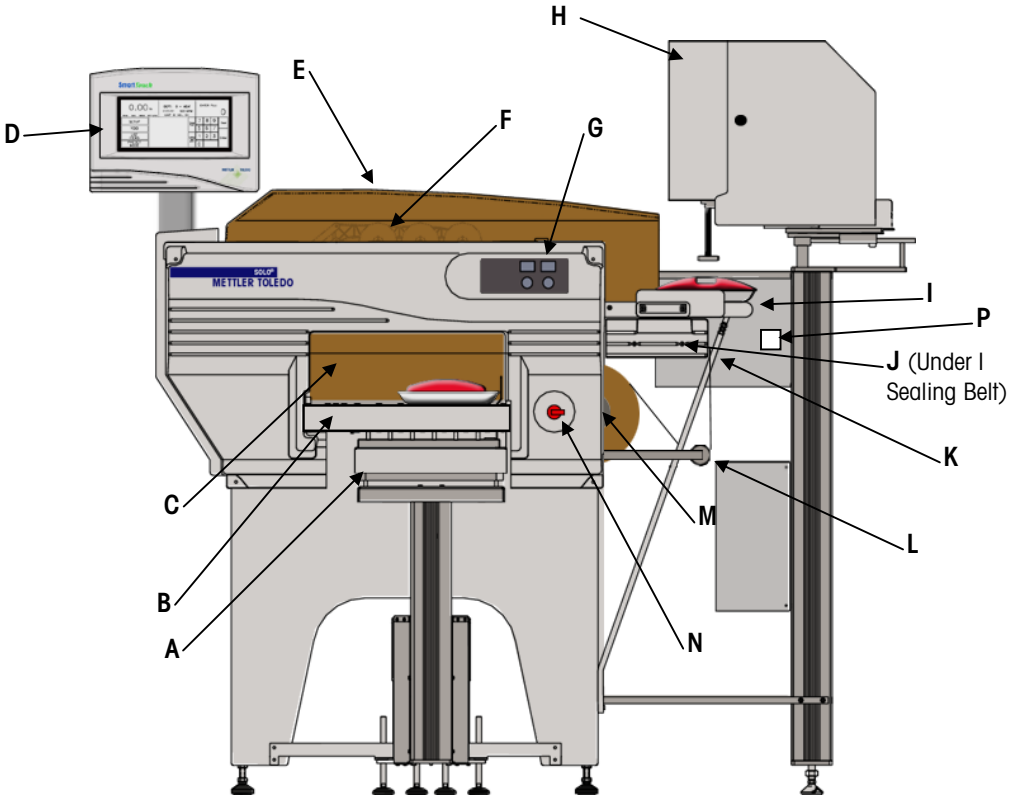
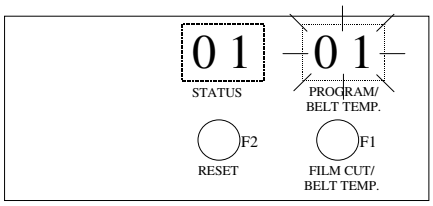


Figure 3-1: SOLO® XL Combo

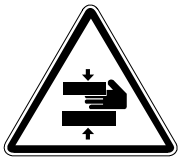
A	Scale	**I**	Sealing Belt
B	Infeed Conveyor/Weighing Platform	**J**	Film Folders
C	Infeed Door	**K**	Curved Roller Assembly
D	Scale Controller	**L**	Dancer Bar
E	Top Cover	**M**	Film Bobbin and Lock
F	Package Pressure Rollers (inside)	**N**	Wrapper Power Switch
G	Wrapper Control Panel	**P**	Labeler Power Switch and Control Box
H	Model 317 Printer/Applicator		

Control Panel

Refer to item G on page 3-1. The Control Panel consists of two 2-digit displays showing **Status** and **Program/Belt Temperature**, and two pushbuttons labeled **Reset F2**, and **Film Cut/Belt Temp**. **F1**.



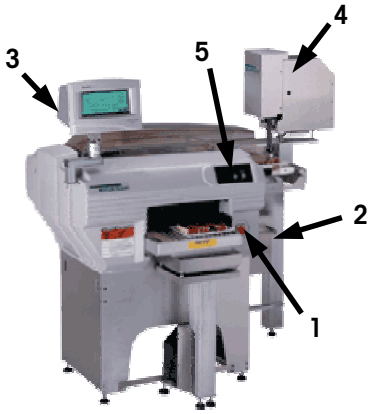
- **Status Display**
  Shows the Status Codes of the machine.
- **Program/Belt Temperature Display**
  Normally displays Wrap Program Number
  Displays Sealing Belt Temperature in setup mode.
- **Reset Button F2**
  Resets machine (***Caution! Pressing Reset initiates a self-test***).
  In setup mode, used to change Wrap Program and Sealing Belt temperature.
- **Film Cut/Belt Temp Button F1**
  Used to cut film.
  In setup mode, used to change Wrap Program and Sealing Belt temperature.



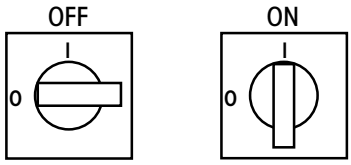
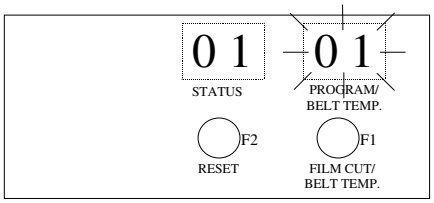
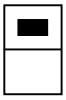
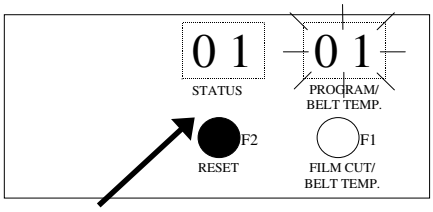
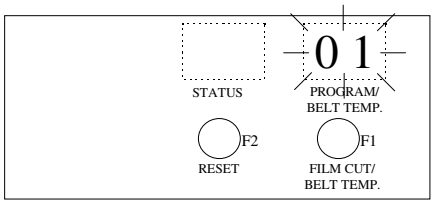
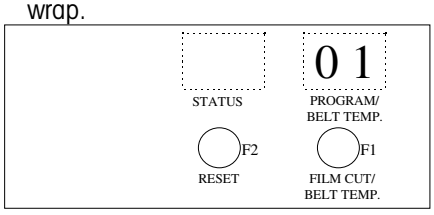
⚠ WARNING!

During self-test the Infeed Belts are in motion and other motors are running. Do not place materials on the belts during this test. Keep hands clear of the machine during the test.

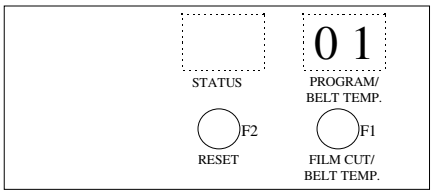
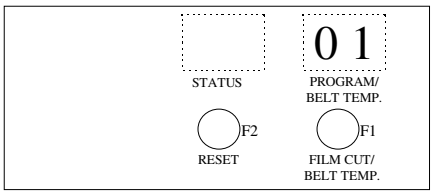
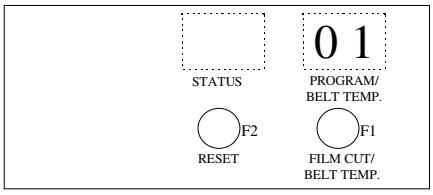
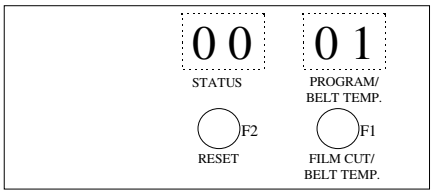
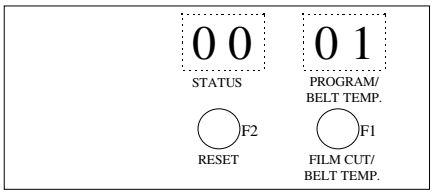
Combo Startup



Warning!
During the self-test, the machine conveyors are in motion. Keep clear of machine during the test. Do not place any materials on the Infeed Belts while the machine is running the test.

Operator Action	Machine Response
Turn power switch (1) from **O** (off) to **I** (on) to turn the wrapper power on.  This controls power to the wrapper motors, electronics, and sealing belt.	• Wrapper startup test. • Status display shows 01 • "PROGRAM/ BELT TEMP" display will blink off/on. 
Flip Rocker Switch (2) on Control Box to ON position.  This switch is on when the LED is illuminated.	Combo Control Board powers up. Vacuum Pump power supply enabled. Scale Lifter power supply enabled.
Flip power switch (3) to ON at the rear of the Controller.	Scale Controller boots up.
Open the Printer door and flip the power switch (4) to ON.	Printer powers up and applicator resets.
Push **F2** button (5) to reset the machine. 	• Machine starts self-test • Status display will be blank. • "PROGRAM/ BELT TEMP" display continues to blink. 
Wait for Sealing Belt to reach specified temperature.	• When "PROGRAM/ BELT TEMP" display stops blinking, the machine is ready to wrap. 

Control Panel Functions

Display on Control Panel	Status or Operator Action	Operation Description
	Machine ready to wrap.	Program Display shows the work program. Status Display shows status codes.
	To Select new Program. **01** Tightest Wrap **03** Standard Wrap **05** Reduced film tension **31** For use with Black Trays	Press and hold the Reset Button **F2** for more than 2 seconds. While holding Reset Button **F2**, select the new program by pressing the Film Cut/Belt Temp Button **F1** until the desired program number is displayed.
	To Change Sealing Belt temperature. **00** Heater Off **01** 78°C (172°F) **02** 81°C (178°F) ↓ Each step = +3°C (5.5°F) **30** 165°C (329°F) Max	Press and hold Film Cut/Belt Temp. Button **F1** for more than 2 seconds. While holding Film Cut/Belt Temp. **F1**, select the new temperature by pressing Reset Button **F2** until the desired temperature setting is displayed. Recommended temperature range is between 18-20.
	Machine stop. Check Status Code.	Status Display shows status code. Refer to the Status Code Table in the Troubleshooting Section. Correct the error condition, then press Reset **F2** to restart.
	To cut film.	Status Display must show **00** or **01**. Press and hold Film Cut/Belt Temp. Button **F1** until film is cut. (Approximately 5 seconds.)

Film Roll Installation

The SOLO® XL Combo requires 13-inch film. The recommended film is a high quality, two-ply 16 micron stretch film that is available through Mettler Toledo Aftermarket. Other films are available that will work on the machine. Contact Mettler Toledo for additional information. To install film on the SOLO® XL Combo proceed as follows:

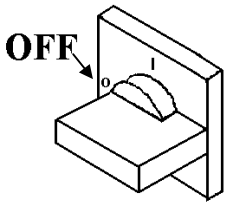


Figure 3-2

Turn the Main Power Switch to OFF.

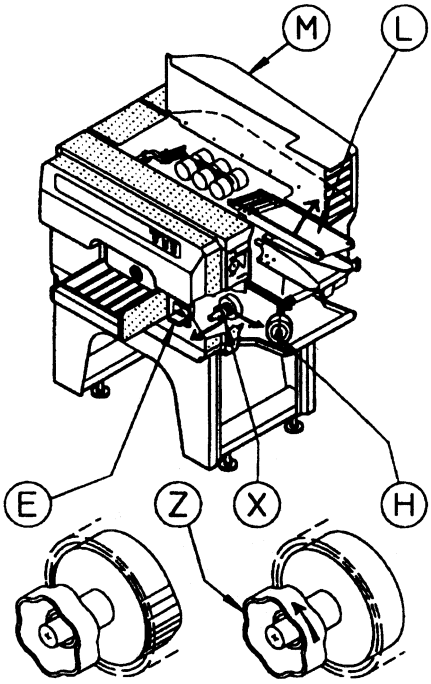


Figure 3-3

Open the top cover (M).

Push the Printer Shelf back, then lift the sealing belt (L).

Release the Bobbin (H) from its housing by moving latch (X) toward the operator side. Pivot the Bobbin outwards.

Hold the Bobbin and rotate the handwheel (Z) counter-clockwise to release the Bobbin Lock.

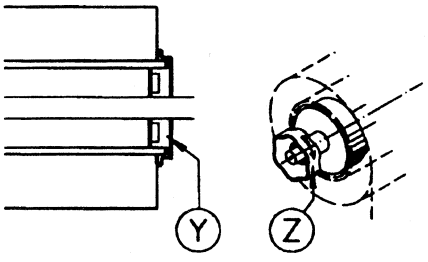
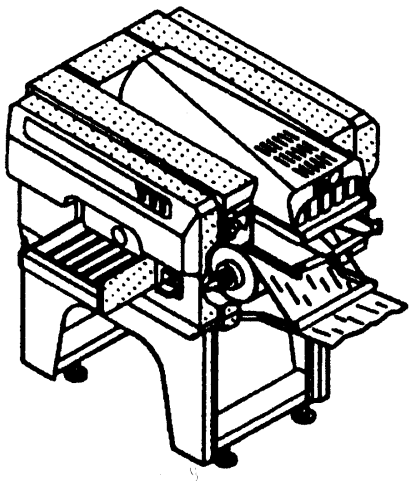


Figure 3-4

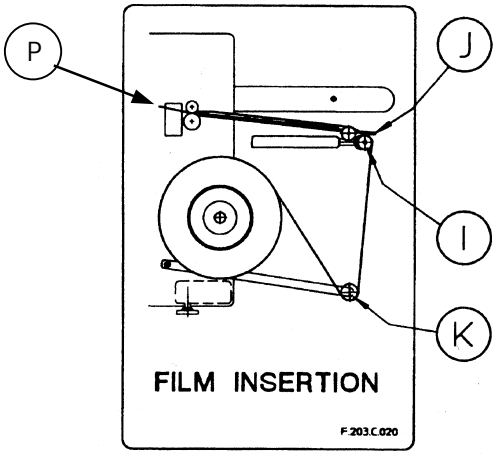
Slide the film roll onto the Bobbin until the roll edge touches the reference disk (Y) in Figure 3-4.

Rotate the handwheel (Z) clockwise to end stop.



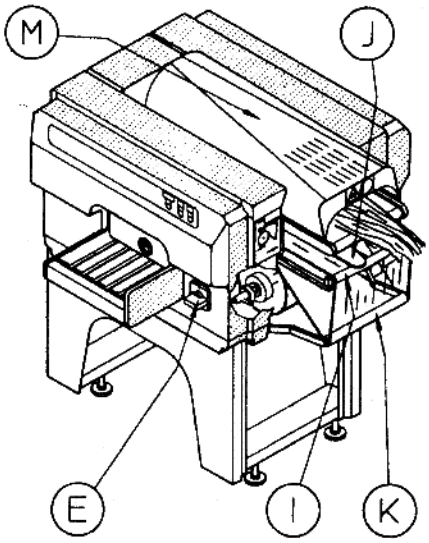
Pull the Bobbin Latch, pivot the Bobbin back to the work position until it locks.

Figure 3-5



Insert the film under the dancer roller (K), over the curved rollers (I), through the film folders (J), and past the distributor (P).

Figure 3-6



Lower the Sealing Belt back to the work position.

Pull out approximately 1 meter (3 feet) of film until it widens at the first roller of the Sealing Belt.

Lower the Top Cover (M) back to the work position.

Turn the Main Power Switch (E) ON to the I position.

Press and hold **F1** until the film is cut, then remove the excess film.

The SOLO® Combo is now ready to wrap packages.

Figure 3-7

Weighing, Wrapping and Labeling Trays

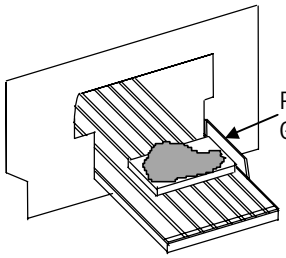
- Within the maximum and minimum size limits, SOLO® XL Combo machines accept any tray size placed on the feed device in any order.
- The wrapper will automatically adjust film quantity and tension, depending on tray dimensions.

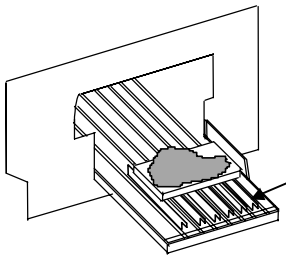
CAUTION!

Do not place a tray on the infeed conveyor when the belts are moving.

- The wrapper starts when a package is placed beneath the Infeed Photoeye.
- Trays must be placed squarely against the Package Guide (parallel to the belts) to be wrapped properly.

Automatic Weigh, Wrap, and Label





Make sure that the scale is at Zero before beginning any weighing operation.

To start automatic wrapping, first key in the PLU number on the Scale Controller.

Place the tray on the Infeed Belts and against the **package guide**. The infeed photoeye will detect the tray and start the machine.

Place the trays on the infeed conveyor only when the conveyor belts are stopped! Do not place a tray or any object on the moving conveyor belts.

The SOLO® XL Combo will first raise the scale to weigh the package. **Do not touch the tray while it is being weighed.**

Once a stable weight is obtained, the scale will be lowered and the package will be conveyed into the machine and wrapped.

A photoeye on the sealing belt is used to stop the package in the proper position for label application.

The label is applied during the dwell time that the package remains on the sealing belt.

Label Position on the tray can be controlled by moving the applicator as desired.

After a brief delay to seal the bottom of the tray, the conveyor will eject the labeled tray and move the next tray into labeling position.

When you are finished running the product, touch the END RUN key on the Scale Controller.

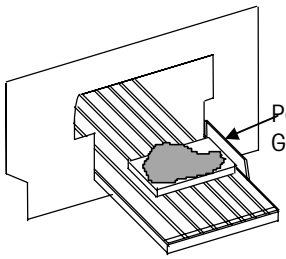
Note: The Combo will switch into a "Wrap Only" Mode when there is an error on the scale controller.

Wrap Only

If a package is fed into the machine after the END RUN key on the scale controller is touched, or if no PLU has been called, the machine will run in Wrap Only mode. The scale table will rise momentarily, but no weight is recorded and no label will print or be applied.

Automatic Weigh and Label

Use this procedure to automatically weigh and label pre-wrapped trays:

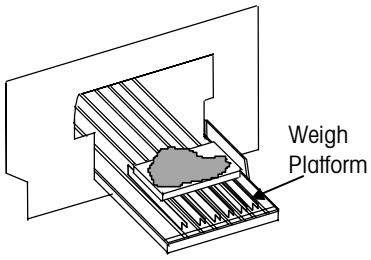


Lift the sealing belt and remove the film from the distributor. Lower the sealing belt.

Key in the PLU number on the Scale Controller.

Place the tray on the Infeed Belts and against the **package guide**. The infeed photoeye will detect the tray and start the machine.

Place the trays on the infeed conveyor only when the conveyor belts are stopped! Do not place a tray or any object on the moving conveyor belts.



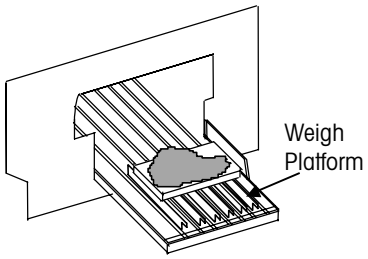
The SOLO® XL Combo will first raise the scale to weigh the package. **Do not touch the tray while it is being weighed.**

After weighing the package, the infeed belts will transport the package to the sealing belt where a label will be applied. The conveyor will eject the labeled tray and move the next tray into labeling position.

When you are finished running the product, touch the END RUN key on the Scale Controller.

Remember to rethread the film when returning to the wrap mode.

Manual Weigh and Label



To weigh trays and apply labels manually to a wrapped tray, first key in the PLU number on the Scale Controller.

Next, touch the LABEL MODE key until MANUAL displays on the second line.

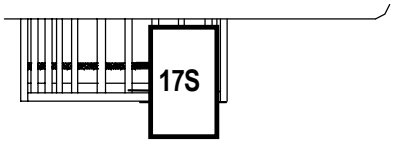
Place the tray on the infeed belts against the package guide. This will raise the scale above the belts for manual weighing. **Do not touch the tray while it is being weighed.**

After weighing the package, the label will automatically print. Remove the package from the scale. Retrieve the label from the printer and apply it to the tray.

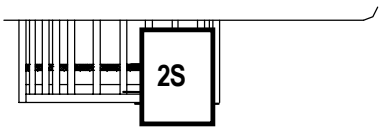
When manually labeling multiple trays, after the label is printed, the tray can be removed and the next tray can be placed on the scale. Remove the label and apply it to the package just removed. Repeat the operation until all of the trays are labeled.

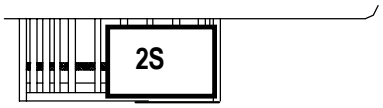
When you are finished running the product, touch the END RUN key on the Scale Controller.

Tray Orientation



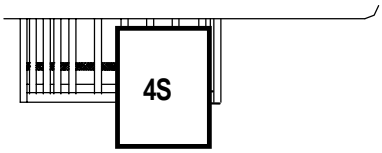
If tray height is less than 3”

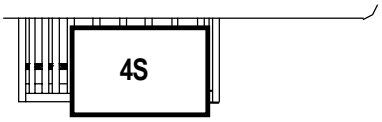




If tray height is greater than 3”

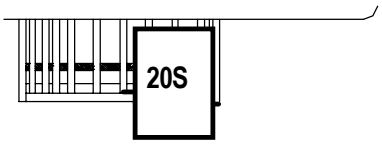
If tray height is less than 3”

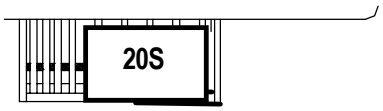




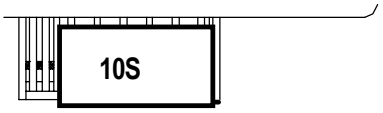
If tray height is greater than 3”

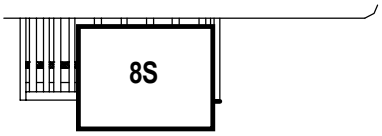
If tray height is less than 3”

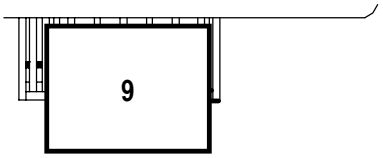


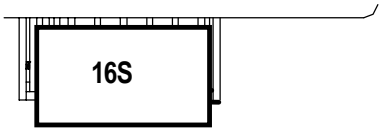


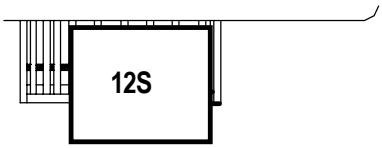
If tray height is greater than 3”

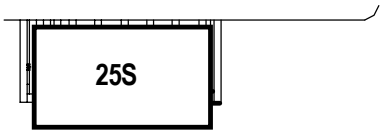


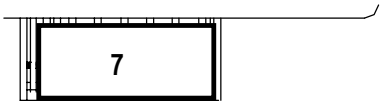


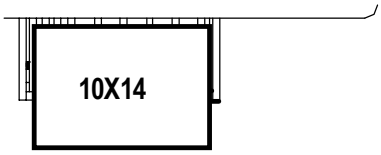




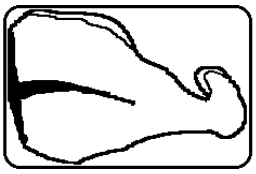






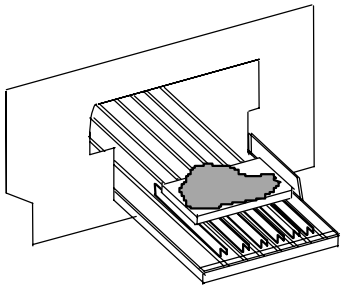


Tips for Trays



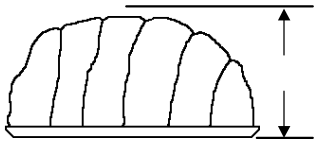
The trays must be stiff enough,

and

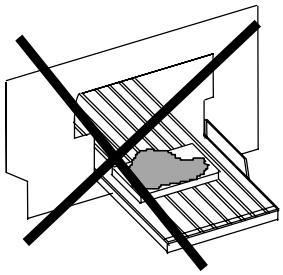


the product must be contained within the tray.

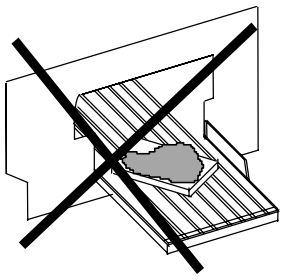
5.0" (127mm)



Height must be less than 5.0″ (127 mm).



The trays must be placed ***against*** the Package Guide to start wrapping. Allow belts to stop before placing next tray.



Trays must be aligned square with the infeed conveyor.

Package Wrapping Check

- Check to see if the tray comes out of the machine well-wrapped and properly sealed underneath. Select the Program that provides the best results for the type of package/product being wrapped.

Program Number	Wrapping Type
01	Wrapping with more film tension and lower items.
03	Standard wrapping for standard tray and items.
05	Reduced tension if film tearing is a problem.
31	Use this program when wrapping black trays.

- The wrapping check should be made after the Sealing Belt temperature is stable (indicated by a steady display on the Program Display).
- If sealing is inadequate, increase the temperature value. If the film appears burned, lower the temperature. The recommended temperature setting is 18-20 for most applications.

Code On Display	Sealing Belt Temperature
00	Heater OFF
01	172°F or 78°C
02	178°F or 81°C
⇓	Every time the code changes one unit, the temperature changes 5.5°F or 3°C.
30	329°F or 165°C

Idle Time

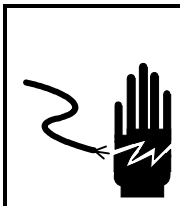
The SOLO® XL Combo power can be left on during short idle periods of time to maintain temperature to the Sealing Belt. If no activity is detected on the infeed Start Switch within 4 hours, the SOLO® XL Combo will automatically lower the temperature on the sealing belt to the minimum setting of 01. A Service Technician can change this time from 1 to 4 hours.

If the SOLO® XL Combo is used daily, leave the power on overnight to keep the unit warm and to control the humidity inside the machine. (Note: Always remove power before cleaning. The power can be turned back on after cleaning is performed.)

If the SOLO® XL Combo will not be used for an extended period of time (more than 1 or 2 days), the power should be turned off using the Power Switch.

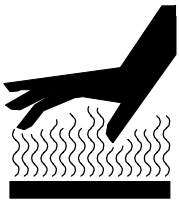
4 Maintenance

Precautions



WARNING

DISCONNECT ALL POWER TO THIS UNIT BEFORE CLEANING



WARNING

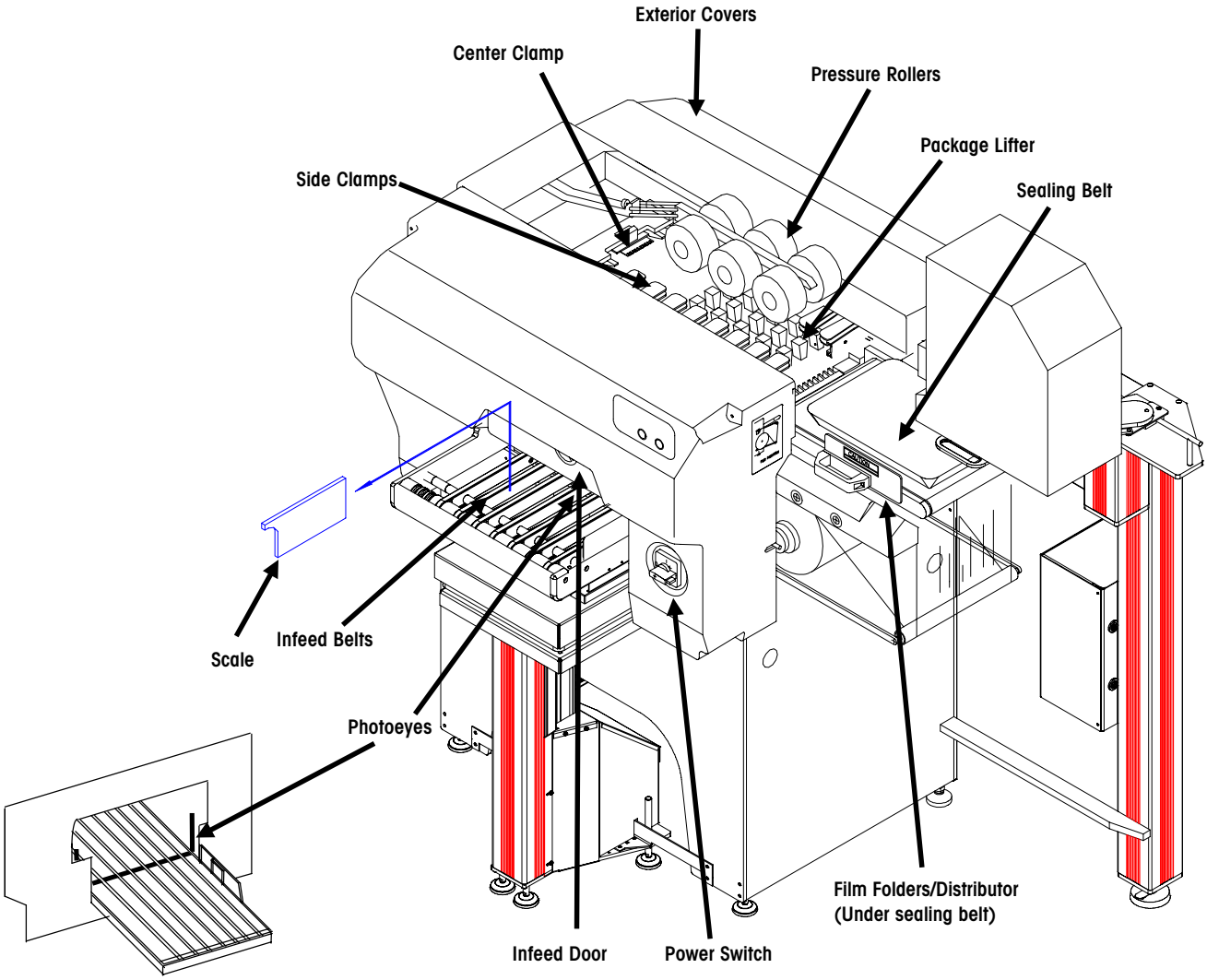
ALLOW SEALING BELT TO COOL BEFORE CLEANING

CAUTION!

Do not direct water or steam at the inside or outside of the machine. Keep moisture away from the inside of the electrical panel and control board. Failure to comply could result in property damage.

Daily Cleaning

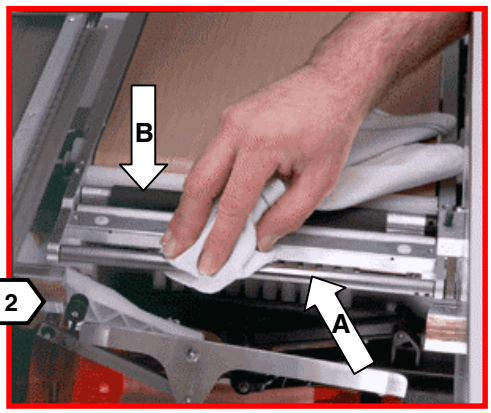
The SOLO® XL Combo is designed to make cleaning operations simple and fast. The following items require attention daily or more frequent as required. Refer to the illustration below for locations of the components on the following pages.



Component Locations for Daily Cleaning

1 Clean the sealing belt with a soft cloth dampened with hot water. **Caution! The belt may be hot. Allow the belt to cool before cleaning.**

Clean the film drive roller (A) with a soft cloth dampened with isopropyl alcohol (recommended) or hot water. Clean the package drive roller (B) with a soft cloth dampened with hot water. Remove any debris from the roller.



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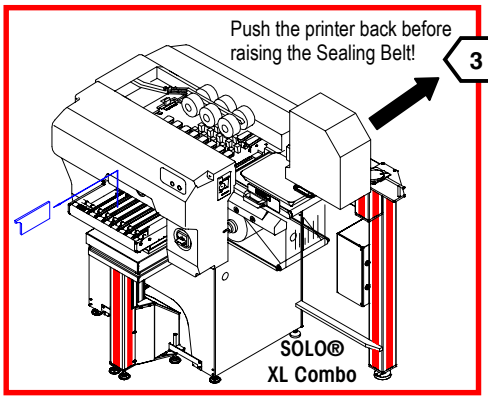
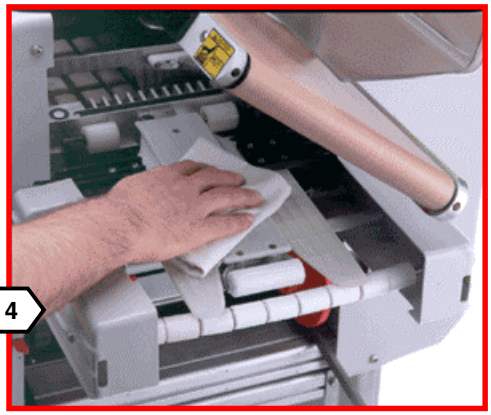


3 Push the printer shelf back before raising the Sealing Belt (see right).

Raise the sealing belt using the handle for access to the distributor, film clamp, and folders below it. **Caution! The belt may be hot.** Clean the film folders, distributor, and curved rollers with a soft cloth dampened with hot water.



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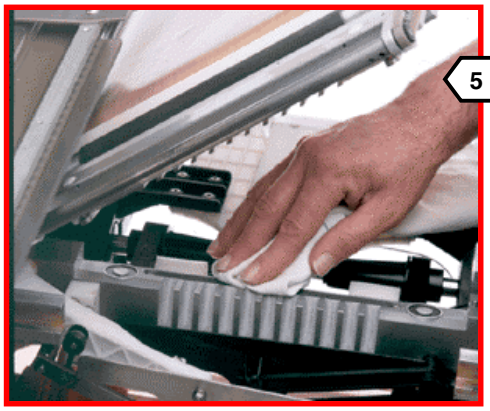
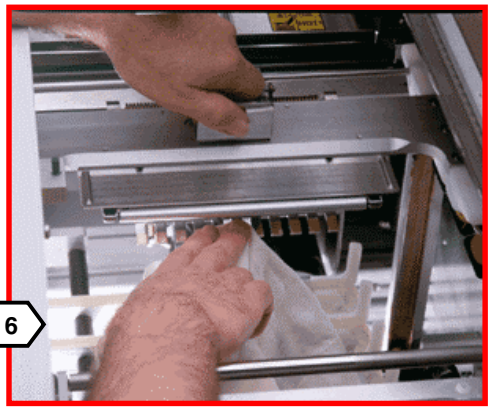


5 While the Sealing Belt is raised, Clean the distributor film clamp with a soft cloth dampened with hot water. When lowering the sealing belt, hold the handle and lower it gently to avoid alignment problems.

Remove any debris from the comb. Clean the film gripper on the center clamp with a soft cloth dampened with isopropyl alcohol (recommended) or hot water. Wipe the surfaces dry when done cleaning. (This must be dry before using the machine.)



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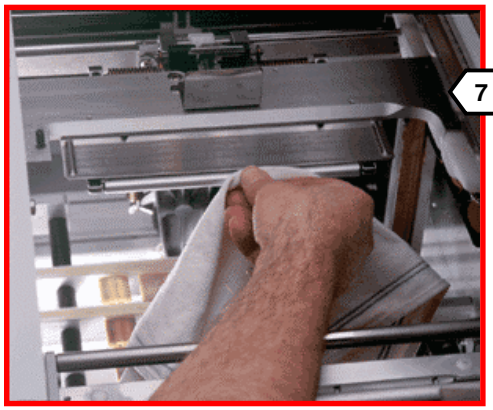
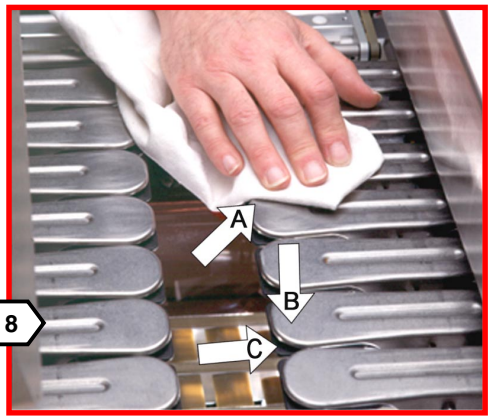


7 Clean the roller on the center clamp with a soft cloth dampened with hot water. Remove any debris from the roller.

Clean the tops (A) of the side clamps with a soft cloth dampened with hot water. Press down on each of the clamps (B) to expose the gripper pads (C). Clean each of the pads (C) with a soft cloth dampened with hot water. Allow to dry before using the machine.



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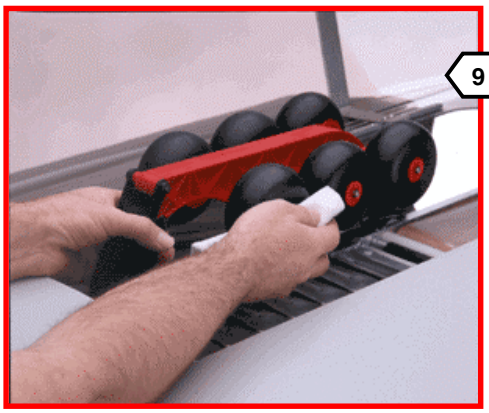


9

Clean the pressure rollers with a soft cloth dampened with hot water. Remove any debris from the rollers.

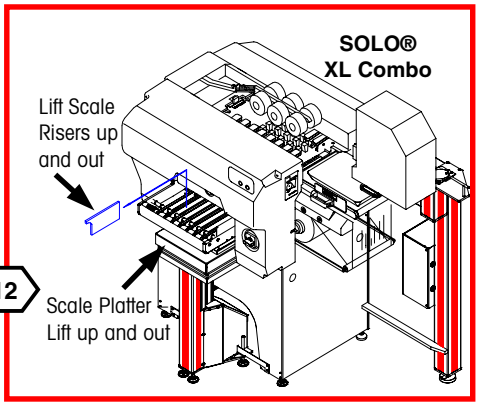
Raise the lifter by pulling it up. Clean the lifter supports with a soft cloth dampened with hot water. Remove any debris from the supports.

10

11

Clean the Infeed Belts and the Infeed Door with a soft cloth dampened with hot water. Wipe the belts and rollers to remove any grease or debris.

Remove the scale risers, then the scale platter by lifting the platter up and out. Clean both daily using hot water, soap, and a brush to clean the slots.



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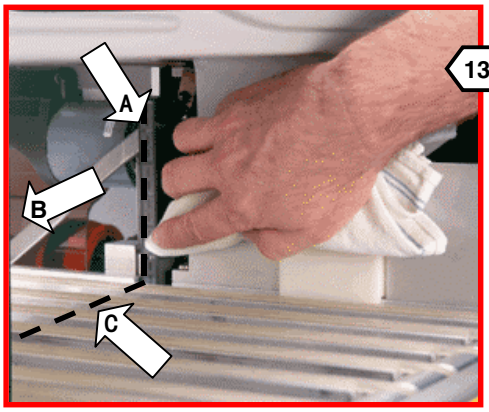


13

Clean the right (A) and left (B) photoeyes and horizontal photoeyes (C) with a soft cloth dampened with hot water. **Do not use a paper towel or other abrasive material. It will scratch the photoeye lens.**

Clean all exterior surfaces with a soft cloth dampened with hot water.

IMPORTANT!
After all cleaning is completed, turn the wrapper power switch back ON.

14

Lubrication

The SOLO® XL Combo does not require frequent lubrication. Machine lubrication should be performed only by qualified personnel during regular periodic maintenance inspections.

5 Troubleshooting

Before You Call For Service

Important Note
For cleaning instructions, refer to Chapter 4 Maintenance before attempting to clean any of the wrapper components.

Before you call for service, cycle the power on the unit. If the problem persists after you take the indicated steps, contact your service agent. Listed below are some common symptoms that could be encountered.

SYMPTOMS	CAUSE	SOLUTION
• Film Tearing • Film Tracking Poorly	• Bad Roll of Film.	• Replace Film with New Roll.
• Trays Left Open • Poor Overwrap • No Overwrap • Short Overwrap	• End of film roll. • Film Pulling Out of Center Clamp. • Film pulling out of side clamps. • Rollers on Sealing Belt Dirty.	• Replace roll of film. • Clean Center Clamp and allow to dry thoroughly. • Clean side clamp gripper pads and allow to dry. • Clean Rollers on Sealing Belt.
• Not Picking Film	• Sealing Belt Not in Closed Position. • Film Not Loaded Properly. • Center clamp dirty. • Film wrapped around distributor film roller.	• Lift and Re-close Sealing Belt. • Re-load the Film. • Clean Center Clamp and allow to dry. Remove any debris. • Remove any film or debris from distributor film roller.
• Error 64	• Package is too tall.	• Reduce the height of the product on the tray to a maximum of 5″ (127,mm).
• Error 61 Displayed on Trays Normally Wrapped	• Infeed Belts Slipping.	• Clean and Dry Infeed Belts.
• Error 99, 63	• Photocells Dirty.	• Clean Photocells.
• Short Overwrap	• Rollers on Sealing Belt Dirty.	• Clean Rollers on Sealing Belt.
• No Power	• Main switch turned to **O.** • Inadequate wiring.	• Turn the Power Switch to **I.** • Check store circuit breaker. • Check the wiring.

SYMPTOMS	CAUSE	SOLUTION
Irregular package wrapping	• Film roll out of position	• Arrange the film roll in the correct position.
	• Film clamp grasp insufficient	• Check and clean Center Clamp and allow to dry.
	• Side Clamps film gripping insufficient	• Check and clean the side clamps and allow to dry.
	• Film Folder dirty	• Clean the Film Folder.
	• Film loading incorrect	• Reload the film.
	• Sealing Belt Rollers Dirty	• Clean Rollers on Sealing Belts.
	• Work program incorrect	• Change the work program setting.
Poor package sealing	• Sealing belt temperature incorrect	• Check the set temperature value.
		• If sealing belt is too hot, lower the temperature value.
		• If sealing belt is too cold, increase the value.
	• Not Enough Overwrap	• Clean rollers on Sealing Belt
	• Weak Trays	• Change the work program to decrease film tension or use sturdier trays.

In case of jams

If a tray jams in the machine:

- Remove any label from the printer applicator.
- Remove the jammed package from the machine.
- Reset the machine.

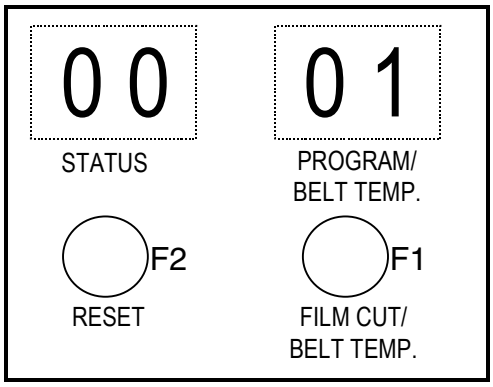
Before starting again, verify the cause of the jam.

Self Test

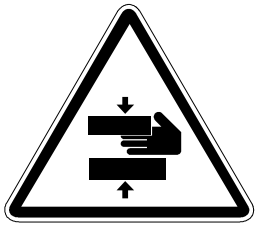
The SOLO® XL Combo is able to self-test and display the following information:

- The type of program being used on the Status Display.
- A status code indicating machine status or probable reasons for stoppages or malfunctions.

The machine conveys this information by special numerical codes shown on the Control Panel Status Display.



The following Status Code List describes the codes. If the code is an error, the section gives steps to take to solve the problem.



WARNING

During the self-test, the wrapper conveyors and motors are in motion. Do not place materials on the belts during this test. Keep hands clear of the machine when the self-test is running.

Status Codes

Wrapper Status Codes

These codes will be displayed on the wrapper control panel.

WARNING!

Turn off the machine and disconnect from power source before performing any repairs. After the repair is completed, turn the machine on and press push-button F2.

Code	Description	Action
00	End of Emergency 03	Press the Reset Button **F2.**
01	Waiting to Start the Program	Press the Reset Button **F2.**
03	Safety Stop Caused by open Infeed Door or Top Cover	Release the Infeed Door. Close Top Cover. Press Reset Button **F2**.
04	Package Jam in machine	Open top cover, remove jammed package, close cover. Press the Reset Button **F2.**
06 thru 54	Internal machine errors	Remove any debris or packages from machine. Press the Reset Button **F2.** If problem persists, call for service.
60	Double package or tray fed too soon. **- or -** Photocells dirty or blocked.	Feed trays only when belts are stopped. Clean Photocells. If the error persists, call for service.
61	Package too long. Photoeyes dirty or blocked. Infeed Rollers/Belts dirty.	Tray exceeds maximum tray dimensions. Turn the tray 90°. Check that the tray dimensions are not greater than listed in the Specifications Section of this Manual in Chapter 1. Clean photocells. Clean Infeed rollers/belts. If the error persists, call for service.
62	Package Too Small. **--or--** Photoeyes dirty or blocked.	Check that tray dimensions are not less than the minimum listed in the Specifications Section of this Manual in Chapter 1. Unblock or Clean photocells. If the error persists, call for service.

Code	Description	Action
64	Page too tall Or Photocells dirty or blocked	Check tray height (5″/127mm maximum) Unblock or clean photocells.
65	Photocells not Activated. Package Presence Photoeye is active with no package on infeed belts.	The package has not reached the photoeyes. Re-arrange the tray on the Infeed Conveyor. If the error persists, call for service.
66	Package Presence Photoeye Continuously Activated.	Check the operation of the Package Presence Photoeye. Reflector plate not in proper location. If the error persists, call for service.
67	Pack Placed Incorrectly on the infeed.	The first horizontal photocell has not been activated. Re-arrange the tray on the Infeed Conveyor. If the error persists, call for service.
71 thru 78	Internal Machine Error.	Press the Reset Button **F2**. If error persists, call for service.
79 solid	Error trying to raise or lower scale lift mechanism	Turn the Labeler Power Switch (P on Page 3-1) to OFF, then back to ON. If error persists call for service.
80 blink	Wrapper is waiting for a weigh complete signal from scale controller.	Will occur if there is motion on the scale or if weight is below minimum print threshold.
81 blink	Wrapper is waiting for print complete signal.	Check Printer and Scale Controller for proper operation..
81 solid	Label applied signal was not generated.	Printer may be out of labels. You must press the RESET Button to clear this error.
82 solid	Sealing belt photoeye never blocked	Photo eye and reflector plate may be dirty. RESET button must be pressed to clear this error.
99 blink 63	Multiple Photoeyes Malfunctioning.	Check and clean photocells. Press Reset Button **F2**. If the error persists, call for service.

COMBO SPECIFIC Errors
Error 79 through 82 are specific to weighing and labeling.

Controller Status Codes

These codes will be shown on the scale controller.

Code	Description	Action
120	Weigh Complete Timeout Error.	No stable weight 5 seconds after scale is activated (below minimum print threshold).
130	Package Timeout Error.	Label was not printed and applied within the allotted time. Touch screen to clear error and reset scale. Remove any labels present on the printer.
131 to 136	Indicates an error with the label applicator.	Cycle power to printer to reset applicator. Touch the screen to clear error and reset scale equipment
137	Label present error.	Take label sensor is blocked, remove any label present. Touch screen to clear the error and reset scale equipment.
150	Wrapper Error Occurred. Wrapping operation halts.	Any packages in process will not be labeled. Press RESET button on wrapper and remove any labels present on printer.

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